

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021134**Date Inspected:** 04-Oct-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Li Yan Hua**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

Bay 16/OBG 13BW Assy

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld joint LD3032-001-116 located on OBG Segment 13BW lifting Bracket. The welder is identified as 045143. ABF Quality Assurance (QA) is identified as Shi Li You. The welding variables recorded by QC appeared to comply with the WPS B-T-2232-TC-U5-F. See attached photograph Pic_001.

Bay 16/OBG 13AW Assy

This QA Inspector observed the following work in progress:

Flux Core Arc Welding (FCAW) in the 2G position of weld joint LD3034-001-056 located on OBG Segment 13AW lifting Bracket. The welder is identified as 205183. ABF Quality Assurance (QA) is identified as Shi Li You. The welding variables recorded by QC appeared to comply with the WPS B-T-2232-TC-U5-F.

OBG Segment12BE

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This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 4G position of weld joint SEG3002A-004 located on Bike path Side SP to Bottom Panel long seam. The welder is identified as 054013. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS B-P-2214-B-U2-FCM-1. See attached photograph Pic_002.

OBG Segment13CE

This QA Inspector observed the following work in progress:

Shielded Metal Arc Welding (SMAW) in the 2G position of weld joint SEG3003M-227 located on PP115 Lifting Bracket. The welder is identified as 043661. ZPMC Quality Control (QC) is identified as Li Ping. The welding variables recorded by QC appeared to comply with the WPS B-P-2212-TC-U4b-FCM-1.

Paint Shop 2 / OBG Segment 11EE

This QA inspector performed internal visual inspection of welds & base metal after blasting along with ZPMC and ABF Quality Assurance (QA) personnel. The member is identified as OBG Segment 11EE.

Bay 14 / OBG Segment 13W Assy

This QA inspector performed Ultrasonic Testing (UT) approximately 10% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated UT report for this date. The member is identified as 13W splice weld as per ZPMC notification # 06855 item # 2.

The weld designations reviewed are as follows:

SEG3013AE-003, 004 and 005



Summary of Conversations:

No relevant conversations reported on this date.

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Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

Inspected By:	Gade,Ramesh	Quality Assurance Inspector
Reviewed By:	McClendon,Timothy	QA Reviewer
